Work Orde Monday, Novemb				*761	70*						Pag	e 1
Item ID: Revision ID:	D3278-041			Accept	*N900	040	100)* s	Setup Star	1.71	S1*	
Item Name:	Support Asser	nbly 39							Stop	, *N	S2*	
Start Date:	11/7/2011	Start Qty: 40.00	*40	*	Cust Item I	D:						, ,
Required Date:	11/16/2011	Req'd Qty: 40.00			Customer:							4
Reference:			4()									
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:		F	Run Star	!/	R1*	•
	QC:				D:	ate:			Stop	` *N	R2*	:
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr								· ·		
D3278	Rev	·C										
100	<u> </u>	<u>.</u>		0.00					/	/	_>	_
100		Small Fab							5./11	1081	38):
Small Fab		Memo		0.00				//>		- 0 (
Small Fab		Rivet space	cers with support as per Dv	vg D3278.					/			
110		QC5- Inspect part com	npleteness to step on W/O	0.00			C	ountes	,			
110				$\geq u_{\ell}$	108			(+39)			
QC		Memo		0.00	· (- C							
Quality Control												
120				0.00		4			ח נייית	//		
120		Small Fab		0.00				6			20	1
120 Small Fab		Memo		0.00				- <i>H</i>	<i>>11 11</i>	//6 (الإكر.	\rightarrow
Small Fab			support as per Dwg D327						//			_
		BOLTS**	*Identify as D3278-041									

W/O:			WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
				· · · · · · · · · · · · · · · · · · ·				, , , <u>, , , , , , , , , , , , , , , , </u>						
	1													
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	\ :	Date:						
		solution:												
NCR:			WORK ORDI	R NON-CONFORMA	NCE (NCR	1)								
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval					
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector					
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Work Ord Monday, Novem				*761	70*							Page 2
Item ID: Revision ID: Item Name:	D3278-041 Support Asser	mbly		Accept	*N900	040	100	* s	etup	Start Stop	171.	S1* S2*
Start Date: Required Date: Reference:	11/7/2011 : 11/16/2011	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:				.		
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate: ate:		R	un	Start Stop		R1* R2*
Sequence ID/ Work Center I 130 *130* QC Quality Control 140 *140* Packaging Packaging	D	Operation Description QC5- Inspect part comple Memo Identify as per dwg & Sto		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Code	Accept Qty Curter (737)	Reji Qty		Reject Number	Insp. Stamp
150 *150* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00						· · · · · · · · · · · · · · · · · · ·	11/11,	15 4

W/O:			WC	RK ORDER CHANG	GES					r. y
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	(Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					•		1			
Part No	•	PAR #:	Fault Cate	gory:	NCR: Y	es No	DQA	·	Date: _	
	Re	esolution:	Disposition	າ:	QA: N/C	Clos	ed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	ction B	ın &	Verifica		Approval	Approval
	J	Section A	Chief Eng	Chief Eng	D	ate	Sectio	n C	Chief Eng	QC Inspector
						:				
				•						

Picklist Print

Monday, November 07, 2011 12:59:15 PM

Work Order ID: 76170

76170

D3278-041 Parent Item:

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

A04.04.19New issueKJ/JLM

B 07 08 21 Cho rivet per PAR 185

EC Verified by ILM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1		Manufactured	No			100	Each	75.0000	1	490	//		
D3278-1									**	JS11)	/11/08	7	-
				Location	<u>n</u>	<u>Loc</u>	<u>Qty</u>	Loc Code					
				GA			75				_		
					73412		35		_				
					74878		40			_3/	-		
D3278-2		Manufactured	No			100	Each	75.0000	1	40			
D3278-2									**	4	11/11/	108	
				Locatio	<u>n</u>	Loc	Oty	Loc Code			, ,		
				CA			40		_	16	_		
					74879		40			<u> </u>	_		
			-	GA			35		_		_		
					73413		35				***		
D3278-3		Manufactured	No			100	Each	75.0000	1	40	//		
D3278-3									**		5/1/11	100	
Spacer										11			
•				Locatio	<u>n</u>	Loc	Oty	Loc Code		//	/ /		
				GA			75				~~		
					70984		60			3	M-14		
					734146		15		_		_		

- 4													
W/O:		The state of the s	WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							•						
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Y	es N	o DQ/	\ :	Date:				
	Re	esolution:	Disposition	n:	_ QA: N/C	Clos	ed:		Date:				
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (N	CR)							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Siç	ın &	Verific Section		Approval Chief Eng	Approval QC Inspector			
			Chief Eng	Chief Eng	D	ate				<u> </u>			

Monday, November 07, 2011 12:59:16 PM

Work Order ID: 76170

76170

D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Parent Item:

Purchased

No

100 Each 12,685.00

**

MS21042L4

Location Loc Qty Loc Code ST300 1685

117441 51 117601 532 118451 133 118927 969 ST516 6000 119017 6000 ST518

119075

118078 118706

118838

119449

Location

ST357

5000

5000

Loc Qty

1451 443

8

500

500

Each

Each

786

AN4-13A

Purchased

No

120

120

1,451.000

**

AN4-13A

Loc Code

AN960JD416

NAS1149D0463J Purchased

No

0.0000

AN960.ID416 Washer



**

W/O:			W	ORK ORDER CHANG	FS.					
DATE	STEP	PRO	OCEDURE CHA			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·								HP4 P-AF
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	: Yes	No DQ	A:	Date:	
	Re	esolution:	Dispositio	n:	QA:	N/C Clo	sed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial	Action Description	tion B	Sign &	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				
				•						·
	1			4			1			

Monday, November 07, 2011 12:59:16 PM

Work Order ID: 76170

76170

D3278-041

Parent Item:

D3278-041

Parent Item Name:

Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

Manufactured No

No

Each

243.0000

**

Loc Qty Loc Code 94 72811 94 149 67826 6 70974 3 73398 140

120

MS20426AD3-6 Purchased

MS20426AD3-6

Rivet

Location ST470 ST476 120 Each 3,205.000

Location Loc Qty Loc Code ST316 3205 105055 115 116289 3090

**

156

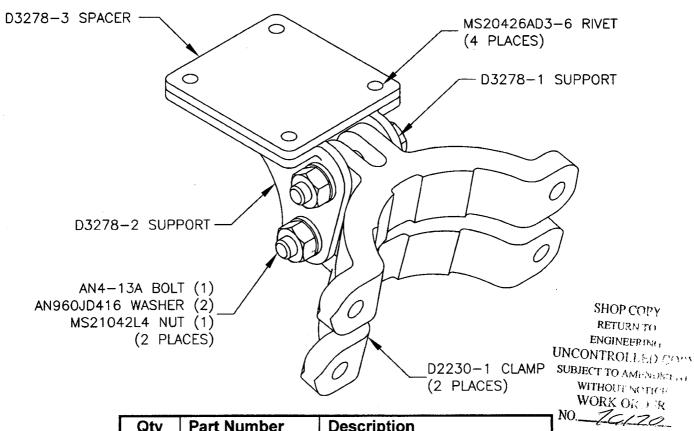
W/O:			WORK ORDER CHANGES												
DATE	STEP	PR	OCEDURE CHAN	IGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Part No	•	PAR #:	Fault Categ	ory:	NCR:	Yes N	lo DQA :	:	_ Date: _						
	Re	esolution:	Disposition	:	QA: N	/C Clo	sed:		Date:						
NCR:	·		WORK ORDE	R NON-CONFORM	IANCE (NCR)									
DATE	STEP	Description of NC			ction B		Verifica	tion	Approval	Approval					
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	ı C	Chief Eng	QC Inspector					
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l	4	9 4	D3278 SHEET	1 OF
DATE			TITLE	SCAL
07.	07.24		SUPPORT ASSEMBLY	NT
Α		04.03.03	NEW ISSUE	
В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
С		07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
Х	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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19									
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A :	Date:	
	Res	olution:	Disposition	·	_ QA: N/C CI	osed:		Date: _	
NCR:	\(\frac{1}{2}\)		WORK ORDE	R NON-CONFORMA	ANCE (NCR)			
		Description of NC	Corrective Action Secti		Verific	ation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
,									

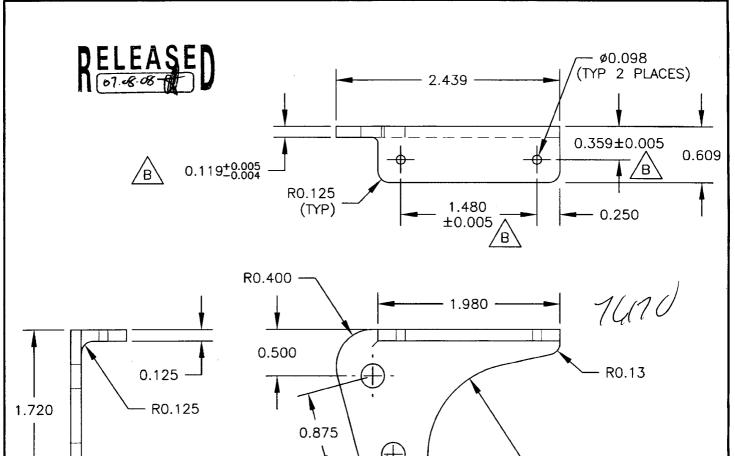


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DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1

R1.00

Ø0.257

(TYP 2 PLACES)



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160)

R0.375

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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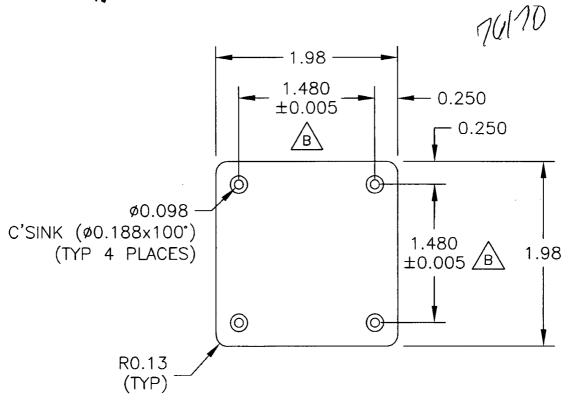
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W/O:		WORK ORDER CHANGES							-
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
Resolution:			Disposition	_ QA: N/C C	QA: N/C Closed: Date:				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE STEP	CTED	Description of NC Corrective Action Section				Verification		Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1





D3278-3 SPACER

1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL

(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR

DELRIN II 150E OR ACETRON GP ACETAL (REF. DART SPEC. M-DELRIN-S.125)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:	WORK ORDER CHANGES							<u></u>		
DATE	STEP	PROCEDURE CHANGE			Ву	Dat	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Cate	jory:	_ NCR: Ye	es No	DQA:	Date:		
Resolution:			Disposition	Disposition: QA			QA: N/C Closed: Date:			
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
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NOTE: Date & initial all entries